

Date: Wednesday, 26/11/2008 8:18:59 AM  
 User: Jean-Luc Menard

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BLADE FITTING
<b>Job Number</b> :	43730		
<b>Estimate Number</b> :	12299		
<b>P.O. Number</b> :		<b>Part Number</b> :	D3488041
<b>This Issue</b> :	26/11/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3488 / DSK101
<b>First Issue</b> :	1 /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41853	<b>Drawing Revision</b> :	B / D
<b>Written By</b> :	<i>[Signature]</i> 07-11-26	<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	03/12/2008
<b>Comment</b> :	Est Rev:A New Issue 06-02-28 JLM Est Rev:B As per Rev B 06-03-30 JLM Est Rev:C Now On Doosan Lathe JLM Verified BY:DD		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6103003 Round Billet, Aluminum



Comment: Qty.: 1.0000 Each(s)/Unit: Total: 1.0000 Each(s)  
 Alluminum: Round Billet D6103-003  
 Batch: 13 42281 (1)

2.0 DOOSAN LATHE DOOSAN LATHE



Comment: DOOSAN LATHE  
 1-Turn as per Dwg DSK 101 & Folio FA625  
 2-Deburr SA 08/11/26 (1)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE SA 08/11/26 (1)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 1-Machine as per Folio FA625 & Dwg D3488  
 2-Deburr 20 08/11/27 (1)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 20 08/11/27 (1)



## Process Sheet

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Drawing Name: BLADE FITTING

Job Number: 43730

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/12/01 (1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS 08/12-101 (1)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:10  
320 °F  
11:40

M-L 08/12/01

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/12/01 (1)

10.0

ALS71032225

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 ALS7-1032-225 Insert

M100621

M-L

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg D3488

M-L 08/12/01

12.0

QC5

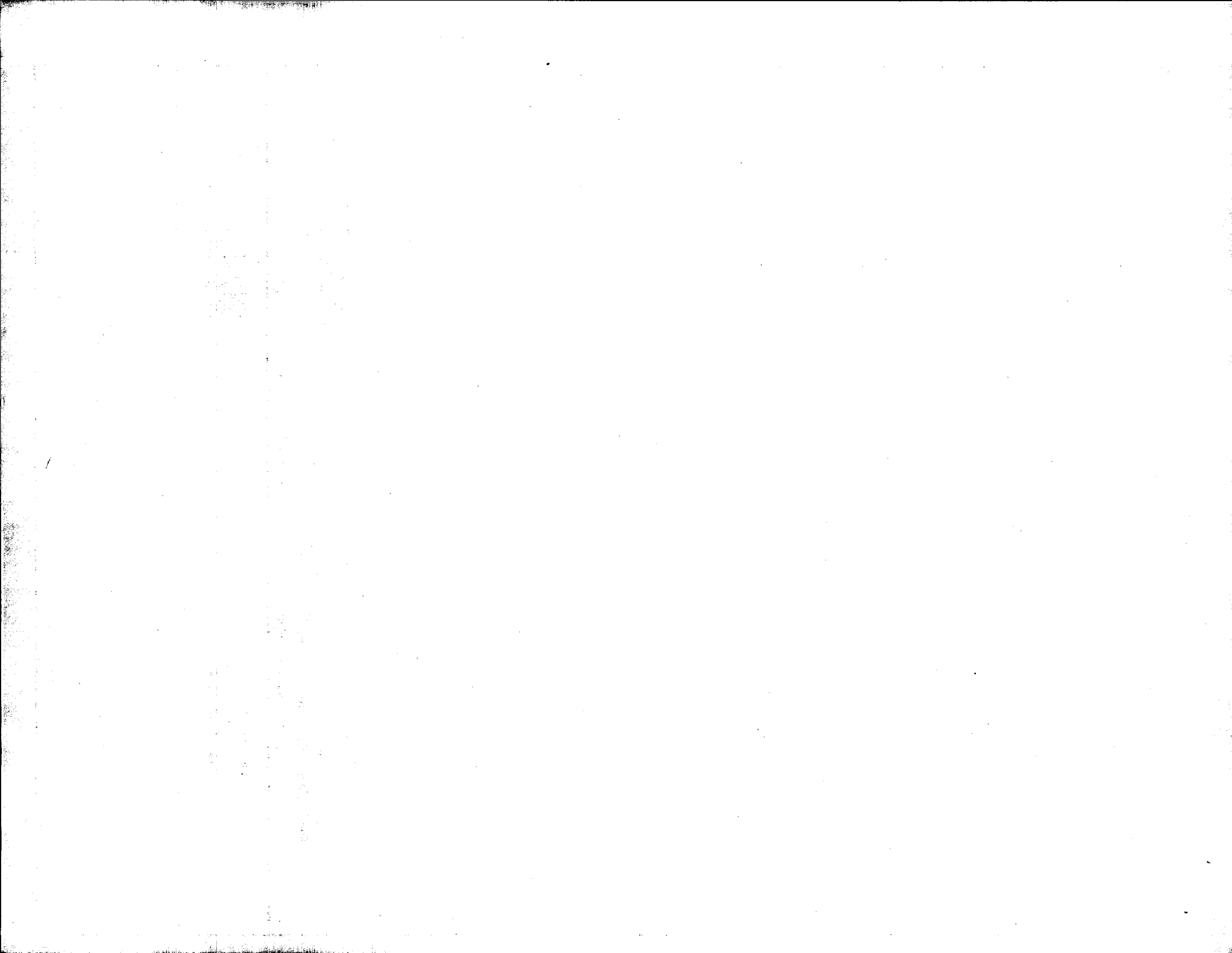
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 08 12 01

(1)



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLADE FITTING

Job Number: 43730

Part Number: D3488041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(14)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

FP-8

m-h 08/12/01

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/02

14

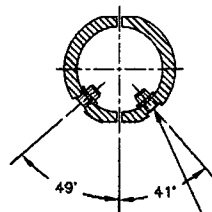
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



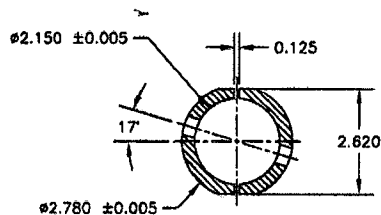
mf 08-12-01

w/043730



SECTION B-B

Ø0.297  
C'BORE Ø0.430 x 0.100  
INSTALL ALS4-1032-225 (OR AKS4-1032-225  
OR ALS7-1032-225 OR AKS7-1032-225)  
INSERTS AFTER FINISH  
(4 PLACES)



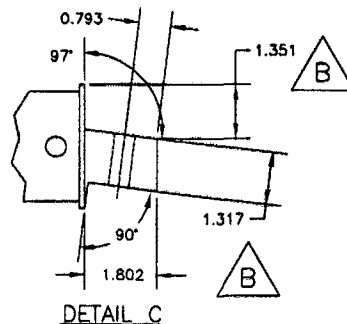
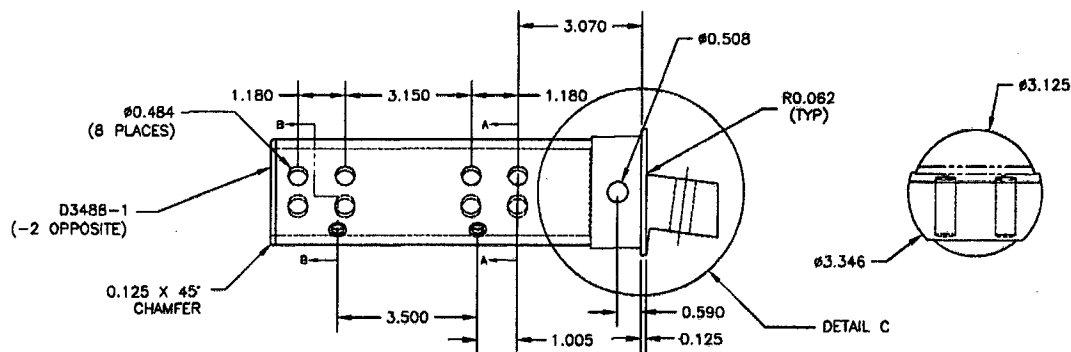
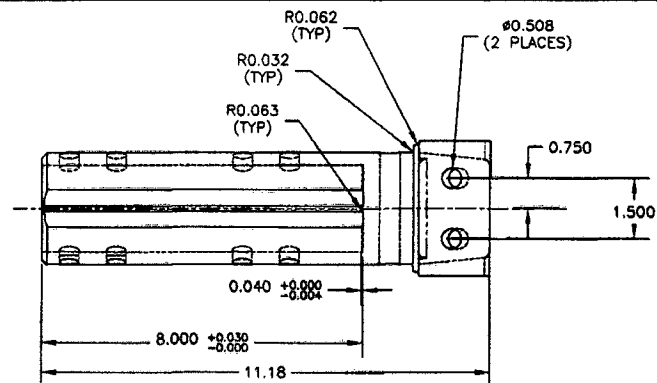
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR PER QQ-A-225/9 (REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DETAIL C

D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED  
06.03.15 PH  
PER DS  
ICN #784

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		SCALE 1:3

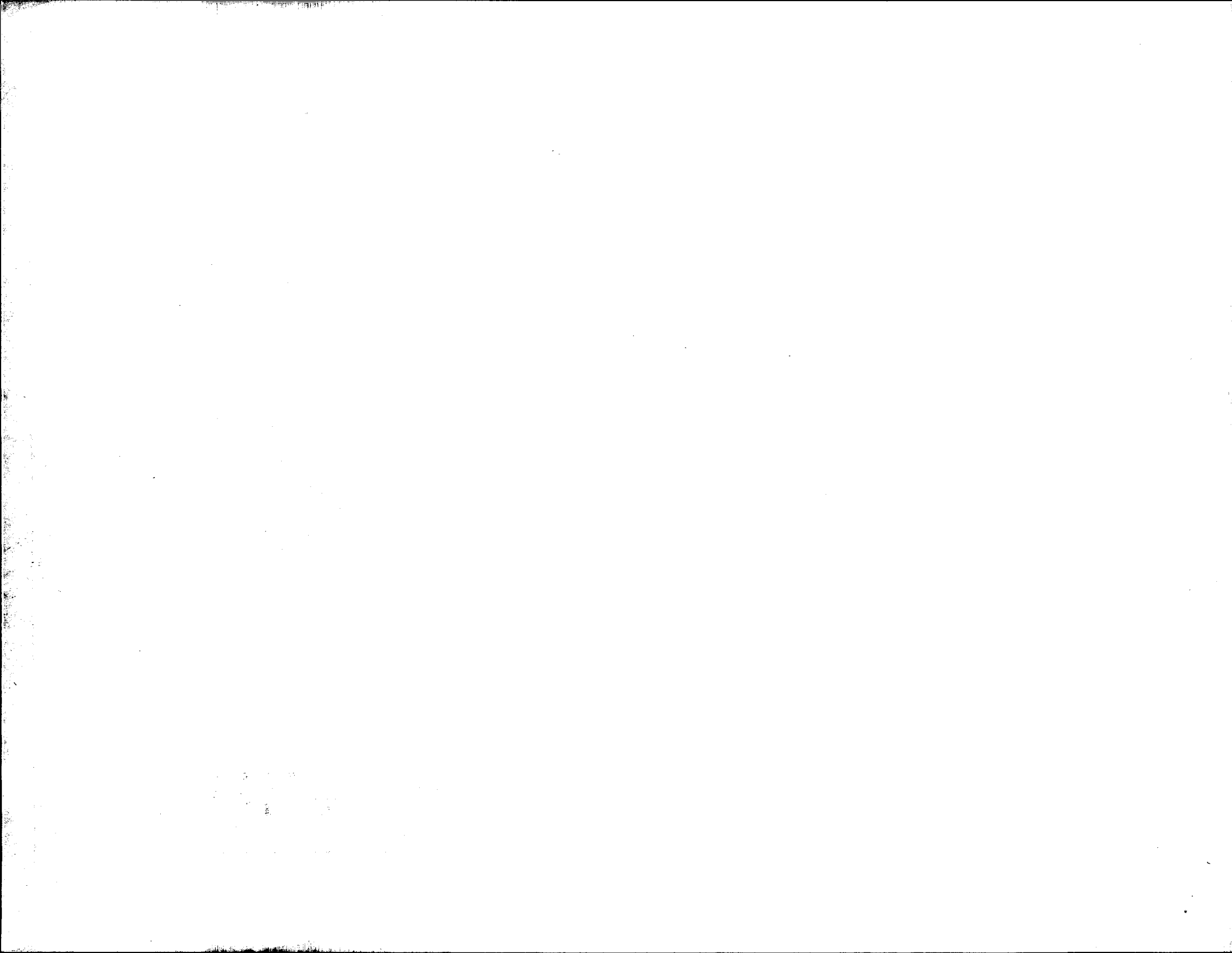
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DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

DRAWING NO. D3488

SHEET 1 OF 1



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>43730</b>
<b>Description: Blade Fitting, LH / Turning Detail for D3488-1/-2</b>	<b>Part Number:</b>	<b>D3488-1</b>
<b>Inspection Dwg: D3488 / DSK101 Rev: B / D</b>		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
Ø2.150	+/-0.005	2.145	/			
Ø2.780	+/-0.005	2.781	/			
Ø3.125	+/-0.010	3.124	/			
Ø3.346	+/-0.010	3.344	/			
0.125 x 45°	+/-0.010 x +/-0.1°	.118 x 45°	/			
8.000	+0.030/-0.000	8.012	/			
9.250	+/-0.010	9.248	/			
0.188	+/-0.010	.187	/			
R0.032	+/-0.010	R.032	/			
R0.062	+/-0.010	R.062	/			
Ø0.297	+0.005/-0.001	Ø.299	/			
Ø0.430	+/-0.010	Ø.430	/			
0.100	+/-0.010	.108	/			
0.125	+/-0.010	.126	/			
2.620	+/-0.010	2.618	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	Ø.484	/			
1.180	+/-0.010	1.180	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.0695	/			
<del>8.000</del>	<del>+/-0.010</del>	<del>8.0</del>				
R0.063	+/-0.010	R0.063	/			

N/A  
2/18/11



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	43730
<b>Description:</b> Blade Fitting, LH / Turning Detail for D3488-1/-2		<b>Part Number:</b>	D3488-1
<b>Inspection Dwg:</b> D3488 / DSK101 <b>Rev:</b> B / D		<b>Page 2 of 2</b>	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	1.509				
0.750	+/-0.010	0.750				
1.500	+/-0.010	1.500				
11.18	+/-0.030	11.184				
R0.062	+/-0.010	0.062				
0.125	+/-0.010	0.130				
0.590	+/-0.010	0.590				
0.793	+/-0.010	0.793				
1.351	+/-0.010	1.349				
1.317	+/-0.010	1.317				
1.802	+/-0.010	1.802				

<b>Measured by:</b>	29	<b>Audited by:</b>	IL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	05/11/09	<b>Date:</b>	08/12/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat	KJ/JLM	

P/O D3488-041